



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2600-1-190
Job Sheet 181032



Part No: D2600-1-190

Job Qty: 70 ea

Part Name: Extrusion Round 3" 206



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/19/18

Job Tracking No:

Due Date: 9/12/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV E

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	70 pcs		9/12/18	0.00	0.00	Purchasing		At 18/09/24
110	Packaging	70 pcs		9/12/18	0.00	0.00	Packaging2		At 18/09/24
120	QC	70 pcs		9/12/18	0.00	0.00	QC6		At 18/09/24
130	Packaging	70 pcs		9/12/18	0.00	0.00	Packaging3-1		At 18-9-26
140	QC21-SA	70 Ea		9/12/18	0.00	0.00	QC21		

Part Op 100 - Issue P/O: _____ a) Extrude as per Dwg D2600 (130" long) b) Material: 6061-T6 c) Material certification Descriptions: is required. ***EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE***

110 - Ensure material certification is attached

120 - Check Pull test per Dwg D2600 for compliance page attached Check hardness with Webster tester

130 - LOCATION : LG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-1-190P	Extrusion Round 3" 206	70 pcs (1 ea)	100-Purchasing	5113018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2600-1-190P	70	0	0

Part Specifications

Specifications could not be found.

SPECIFICATION CONTROL DRAWING

D2600-X-XXX EXTRUSION

NOTES:

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221

MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 40 KSI
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2600-1 = 0.078 lb/in, D2600-3 = 0.130 lb/in, D2600-5 = 0.045 lb/in, D2600-7 = 0.091 lb/in
- 8) NO TOOLING MARKS
- 9) FOR D2600-1, PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH (EX. D2600-1-160 IS 160" LONG).
D2600-1 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MH-18870
- SIGNATURE ALUMINUM (BON-L) DIE # 897121
- 10) FOR D2600-3, PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH (EX. D2600-3-120 IS 120" LONG).
D2600-3 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MH-18859
- SIGNATURE ALUMINUM (BON-L) DIE # 897122
- 11) FOR D2600-5, PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH (EX. D2600-5-108 IS 108" LONG).
D2600-5 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MS-18871
- 12) FOR D2600-7, PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH (EX. D2600-7-125 IS 125" LONG).
D2600-7 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MS-18872

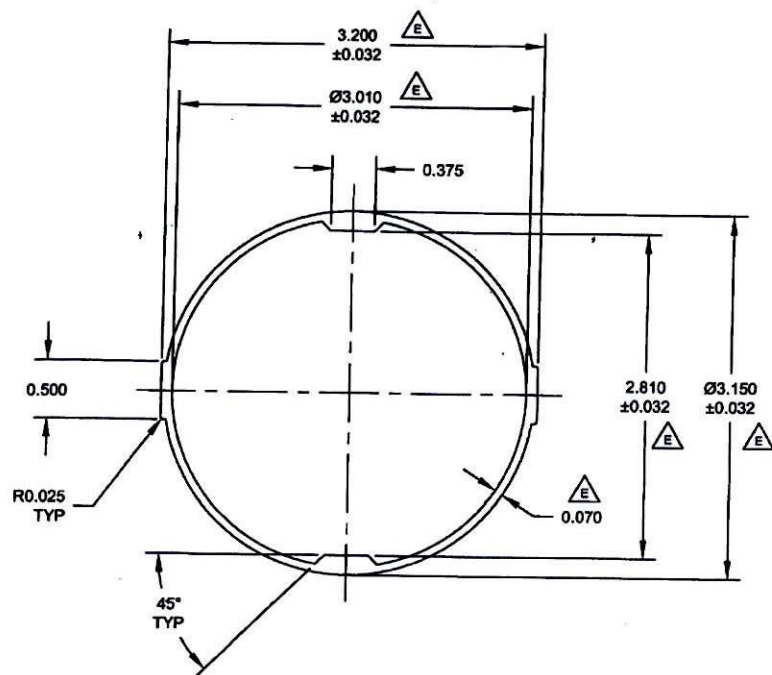
RELEASED
R 2012-01-11

REV.	DESCRIPTION	BY	DATE
E	REFORMAT DWG; ALL DIMS & TOL. UPDATE TO MATCH MFG DIE DWGS; ADD ASTM B221 SPEC (D8-1)	CP	11.10.18
D	INCREASE MIN. UTS TO 40 KSI	DS	98.08.20
C	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	DS	98.04.16
B	CHANGE MATERIAL SPEC.	DS	97.09.09
A	NEW ISSUE	DS	97.01.21
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.18		

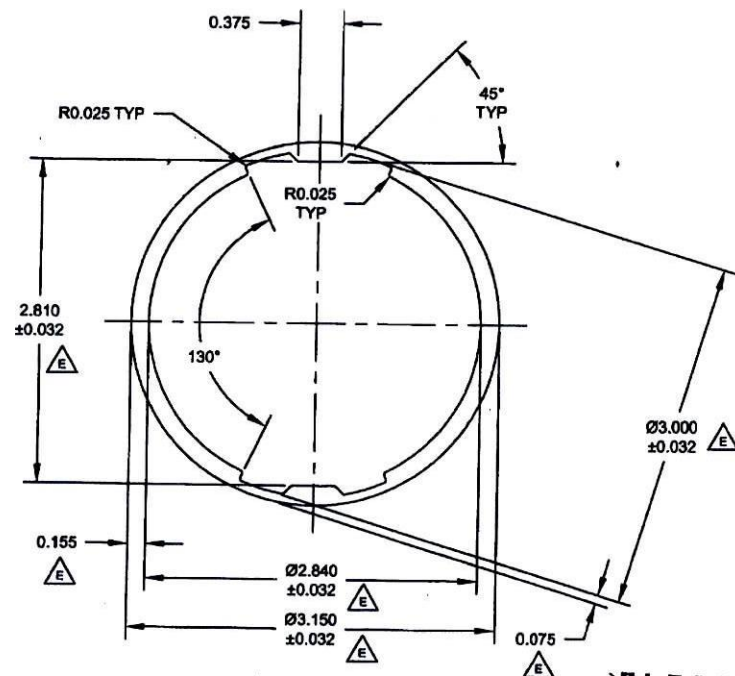
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2600
REV. E
SHEET 1 OF 3
TITLE
EXTRUSION
SCALE
NTS

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D2600-1 EXTRUSION



D2600-3 EXTRUSION

RELEASED
2012-01-10

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	E	D2800	SHEET 2 OF 3
APPROVED	W	TITLE	SCALE
DE APPR.		EXTRUSION	NTS
DATE	11.10.18	COPYRIGHT © 1997 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

PURCHASE ORDER PO040562

Supplier: SIG001-VC
Signature Aluminum Canada Inc.
C/O/ T10322C
PO Box 4488, STN A
TORONTO
ON
M5W 4H1 Canada
Phone: 905-427-6550
Fax: 905-427-2246

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040562

PO Date: 7/23/18

Due Date: 9/14/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments: QUOTE NO 07192018-003

E-MAILED
JUL 23 2018

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		D2600-1-160P		Extrusion Round 3" 206 EXTRUDE AS PER DWG D2600 REV. E W/O 181031 EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES,NICKS,DENTS NOTE: MUST BE WELL PACKAGE, IF NOT WILL BE REFUSE	Firmed	-	9/14/18	90 pcs	0 pcs 98x	90 pcs	\$35.71938/pcs	\$3,214.74 At 18/07/24
2		D2600-1-190P		Extrusion Round 3" 206 EXTRUDE AS PER DWG D2600 REV. E W/O 181032 EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES,NICKS,DENTS NOTE: MUST BE WELL PACKAGE, IF NOT WILL BE REFUSE	Firmed	-	9/14/18	70 pcs	0 pcs 77x	70 pcs	\$44.21843/pcs	\$3,095.29

Grand Total: \$6,310.03

Order Notes



1850 Clements Road, Pickering Ontario, Canada L1W 3R8 INVOICING AND COMPANY LOCATION

Phone: (866) 587-5780 Fax: (905) 427-2207

Visit us at www.signaturealuminum.comSIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

PACKING LIST

PACKING LIST DATE / DATE DU BUREAU

09-21-18

PACKING LIST NUMBER / N° DE

039400

SALES ORDER NUMBER / N° DE COM

133070

ACCT# 46024

SHIP TO / EXPÉDIÉ À DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA PHONE: 613-632-5200				SOLD TO / VENDUE À DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA PHONE: 613-632-5200				ERMS / FREIGHT PP		REFER TO THESE NUMBERS ON ALL CORRESPONDANCE REFEREZ-VOUS A CES NUMEROUS POUR TOUTE CORRESPONDANCE			
CUSTOMER ID / ID DU CLIENT 46024		ORDER DATE / DE LA COM 07/23/18		CUSTOMER PO NUMBER / CLIENT PO Nombre PO040562				JOB / FICHIER		CREDIT REP / REP DU CRÉDIT 042		SALES REP / REP. DES VENTES R. BLAIS	
				BILL OF LADING NUMBER / NO. DE CONNAISSEMENT 039400				CARRIER / TRANSPORTEUR KANA RACINE		FIELD SALES REP / REP REGIONAL DES VENTES G.ATTENBOROU		CUST SERVICE REP / REP. SERVICE CLIENTELE S1S	
ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison		
002	1,112	LB		DAA-897121-3	6061 T6		3	1,241	1,140	LB			
	504	KG		D2600-1-190P	190.0000 IN			563	517	KG			
Y	70	PC			Cut (+): 0.1180 Cut (-): 0.0000	Min: -10 % Max: 10 %			77	PC			
AT													
						905663 / 447116	1	527	487		33 PC		
						905663 / 447117	1	527	487		33 PC		
						905663 / 447118	1	187	165		11 PC		

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives. No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on our website.

Page 2 of 2

5	2,560	2,410	LB
	1,161	1,093	KG
		175	PC
TOTALS			

ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

CUSTO

DATE OF DELIVERY

DRIVER

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No.	Sales Order	Page
09/10/2018	5495074	133070	1
Cust PO	B/L No	Lot	Date
PO040562	039400	905663	09/21/18

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
002	DAA-897121-3	190" Mill 6061 T6	D2600-1-190P
Gross Weight	1,241 LBS		
Net Qty	1,140 LBS 77 PCS 3 PKGS		
Specification	Die Desc		
AMS QQA 200/9 + ASTM B221-08			

Mechanical Tests:

<u>Tensile</u>	<u>Yield</u>			
<u>MPA / KSI</u>	<u>MPA / KSI</u>	<u>% Elongation</u>	<u>Conductivity</u>	<u>HRE</u>
283.5 / 41.1	244.2 / 35.4	10.9	N/A	90

Chemical Analysis:

<u>Si</u>	<u>Fe</u>	<u>Cu</u>	<u>Mn</u>	<u>Mg</u>	<u>Cr</u>	<u>Zn</u>	<u>Ti</u>	<u>V</u>	<u>Zr</u>
0.60	0.28	0.23	0.06	0.90	0.06	0.07	0.02	0.01	0.00

*This Material is Made in Canada**This Material is RoHS Compliant*

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Gooder
Quality Manager
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

Rev A

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2600-1-190

PO / BATCH NO.: P0040562 / 5113022

DATE: 18/09/24

MATERIAL CERT REC'D: Yes

THICKNESS ORDERED: 3"

QUANTITY RECEIVED: 77x

THICKNESS RECEIVED: 3"

QUANTITY INSPECTED: 77x

SHEET SIZE ORDERED: —

QUANTITY REJECTED: 0

SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	☒	
CORRECT FINISH	☒	N	
CORROSION	Y	☒	
CORRECT GRAIN DIRECTION	☒	N	
CORRECT MATERIAL PER M-DRAWING	☒	N	ASTM A221
CORRECT THICKNESS	☒	N	
PHOTO REQUIRED	Y	☒	
CORRECT REF # TO LINK CERT	☒	N	LT: 905663
CORRECT MATERIAL IDENTIFICATION	☒	N	
CORRECT M# ON THE MATERIAL	☒	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	☒	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	☒	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DA</u> DATE: <u>18/09/24</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in



Supplier Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: Wednesday, September 26, 2018

Details			
Raised Date 9/26/2018	Status Open	Owner Aboud, Robert	Number NCR18-6958
Target Date 10/26/2018	Standard		Severity
Process Inspection		Audit	
Raised By Person Duval, Patrick	Raised Against (Department or Supplier) Signature Aluminum Canada Inc.		Fault Category Material
Details PO040562 D2600-1-190 job 181032 was found with multiple indentation thru out the length of the extrusion			
Keywords		Product D2600-1-190	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Root Cause			
Target Date 10/6/2018	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	

Corrective Action			
Target Date 10/6/2018	Owner Aboud, Robert	Closed Date	Closed By
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	
1	Duval, Patrick	9/26/2018	9/26/2018
Inspect complete order and set aside the defect ones.		Quarantine qty 53 until further notice	
2	Aboud, Robert	10/3/2018	
contact supplier for corrective action			

Implementing Corrective Action

Target Date	Owner	Closed Date	Closed By
10/6/2018			
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	

Verification & Review

Target Date	Owner	Closed Date	Closed By
	Downing, Eric M		
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	